

Work Order ID 130536

Friday, March 13, 2015 1:31:41 PM

130536

Page 1

Item ID: D3303-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Head Rest

Start Date: 3/13/15 Start Qty: 3.00

B
B
7

Cust Item ID:

Required Date: 3/17/15 Req'd Qty: 3.00

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date: 15-3-13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3303

Rev B

95

0.00

Q5

QC

Quality Control

Memo

PULL FROM STOCK

D3303-041 X3

B128898 X2

B127542 X1

0.00

1 x 119520
1 x 127540
2 x 127539

Handwritten signature

3/13/2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Work Order ID 130536

130536

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Friday, March 13, 2015 1:31:41 PM

Item ID: D3303-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Head Rest
Start Date: 3/13/15 Start Qty: 3.00 *3* Cust Item ID:
Required Date: 3/17/15 Req'd Qty: 3.00 *3* Customer:
Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify with NEW BATCH NUMBER								
	identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303 , then Stock Location: <u>415-0317</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

Handwritten notes: 415-0317, SH457, 15-3-18, 15-04-01

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Picklist Print

Friday, March 13, 2015 1:31:45 PM

Page 1

Work Order ID: 130536

130536

Parent Item: D3303-041

D3303-041

Parent Item Name: Head Rest

Start Date: 3/13/15

Required Date: 3/17/15

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: B04.10.05 Revised Step 5 with headrIPP identification KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3303-041		Manufactured	No				Each	0.0000		3			

D3303-041

Head Rest

**

15-3-13

128898 X2

127542 X1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Wednesday, March 11, 2015

Details			
Raised Date 3/11/2015	Status Open	Owner Forbes, Nigel	Number NCR15-4615
Target Date 3/23/2015	Standard		Severity MAJOR
Process Customer Complaint		Audit	
Raised By Person Summit Helicopters	Raised Against (Department or Supplier) Manufacturing		Fault Category General/Incorrect Process
Details customer, Summit Helicopter John Milko, complaint that the D3303-041 that he received in his D412-724-043/-044/-041 had the foam D3305-1 just fell off when trying to align the head rest.			
Keywords		Product D412-724-011	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 3/20/2015	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	3/13/2015	3/11/2015
investigate how this could have happened		was found that only the 1300 3m adhesive is only applied to the plate and NOT to the foam as it should as indicated by 3m. employees in small fab do not remove the foam from the covers. also it was found that the TCCA # is not being written on the D3303-041 as indicated per the drawing	
2	Downing, Eric M <i>DAVE</i>	3/13/2015	
quarantine all stock D3303-041 & all D412-724 and record all qty's & batches on the quarantine item list			

-1D D3303-041 128898 x2
127542 x1

-1D D412-724-041 x4 128966

	Downing, Eric M	3/20/2015	
retrain all small fab employees that the 3m adhesive needs to be installed as per the instructions			
4	Menard, Jean-Luc	3/20/2015	
update route to have better instructions on how to install / bond the D3303-41 correctly1-if necessary remove from covering2-apply layer of 3m 1300L to both D3305-1 & to D3303-043 and allow to cure for 4 minutes3-apply another layer to D3303-043 and apply to D3305-1 and allow for parts to bond for 8-12 minutes4- reinstall D3306-041			
5	Menard, Jean-Luc	3/20/2015	
create tooling to help place D3303-043 in the center of the D3305-1 to eliminate it form being installed off center			
6	Poulin, Mario	3/20/2015	
create work order to rework stock accordingly			

Verification & Review			
Target Date 3/20/2015	Owner Smith, Patrick	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	